



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3654-1

Job Sheet 187669



Part No: D3654-1

Job Qty: 4 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/11/18

Job Tracking No:

Due Date: 12/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A New Issue 07-10-29 DD verified by: EC IPP Rev:B ecn1162 08-04-02 DD verified by:ec IPP Rev:C 08-09-17 revB as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Waterjet - Flow - 1	4 pcs	12/28/18	12/28/18	0.00	1.05	Waterjet - Flow	SC 18/12/18
110	QC 2	4 pcs	12/28/18	12/28/18	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 16	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	SC 18/12/18
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

120	QC 8	4 pcs	12/28/18	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 16	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	DAS
					QC 8 - 39	38
					QC 8 - 4	9-89
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
130	Packaging 3-1 - Stock - B4B	4 pcs	12/28/18	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
140	QC 21 - SA	4 pcs	12/28/18	0.00 0.00	QC 21 - SA - 16	
Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB)						DAS
Descriptions: 120 - (QC8- Inspect parts - second check)						21
130 - (Identify as per dwg & Stock Location: _____)						9-89
140 - (QC21- Final Inspection - Work Order Release)						JAN 07 2019
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M304S16GA	304/316 Sheet .063	1.4000 sf (.35 ea)	100-Waterjet - Flow - 1	5156471		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

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Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
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				QC / QA Coordinator	
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Other/Details:					

Part Specifications

Specifications could not be found.

Plex 12/11/18 12:52 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

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Other/Details:					

DART AEROSPACE LTD		Work Order:	187669
Description: Doubler		Part Number:	D3654-1
Inspection Dwg: D3654 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.213	+0.005/-0.001	Ø0.214	1		ISC-07	
0.750	+/-0.010	0.761	1			
0.597	+/-0.010	0.600	1			
1.943	+/-0.010	1.945	1			
3.875	+/-0.010	3.878	1			
4.80	+/-0.030	4.816	1			
5.80	+/-0.030	5.805	1			
1.583	+/-0.010	1.585	1			
1.820	+/-0.010	1.822	1			
3.920	+/-0.010	3.925	1			
6.38	+/-0.030	6.384	1			
7.152	+/-0.010	7.155	1			
8.20	+/-0.030	8.206	1			
0.343	+/-0.010	0.345	1			
1.900	+/-0.010	1.904	1			
3.35	+/-0.030	3.352	1			
3.759	+/-0.010	3.760	1			
0.38	+/-0.030	0.381	1			
0.063	+/-0.010	0.057	1			

Measured by:	3C	Audited by:	38	Preliminary Approval:	
Date:	15/12/18	Date:	19-01-03	Date:	

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	
B	09.12.17	Dimensions updated per Dwg Rev B	KJ	
C	11.01.17	Dwg Rev updated to B	KJ	



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CANADA
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Container No: S138608



Part: D3654-1

Job No: 187669

Serial No/Batch: S138608

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/18/18